

Date: Thursday, 6/15/2006 1:41:22 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 27556	Part Number	: D2530
Estimate Number	: 10333	Drawing Number	: D2530 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/15/2006	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/30/2006
Previous Run	: 26406	Qty:	20
Written By	<i>See JLM comment Below</i>		
Checked & Approved By	: <i>See JLM comment Below</i>		
Comment	Est Rev:E	Removed Purchasing	05-11-07 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	27556A	LOCK PLATE



Comment: Sub-Component LOCK PLATE

2.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 0.4809 f(s)/Unit Total : 9.6180 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: *M01593**SAP 06:07:17*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

*S40 06:07:17**(20)*

4.0	D2534	Lock Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	<i>B27556A</i>

11:06:07/26 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

11:06:07/27 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: 

Date: 06/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

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Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-01-27 (21)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

SC 06/07/31 (21)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PA 06/08/01 (21)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 183

LB 06/08/01

(21)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/03 (21)

Job Completion



CY 06/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

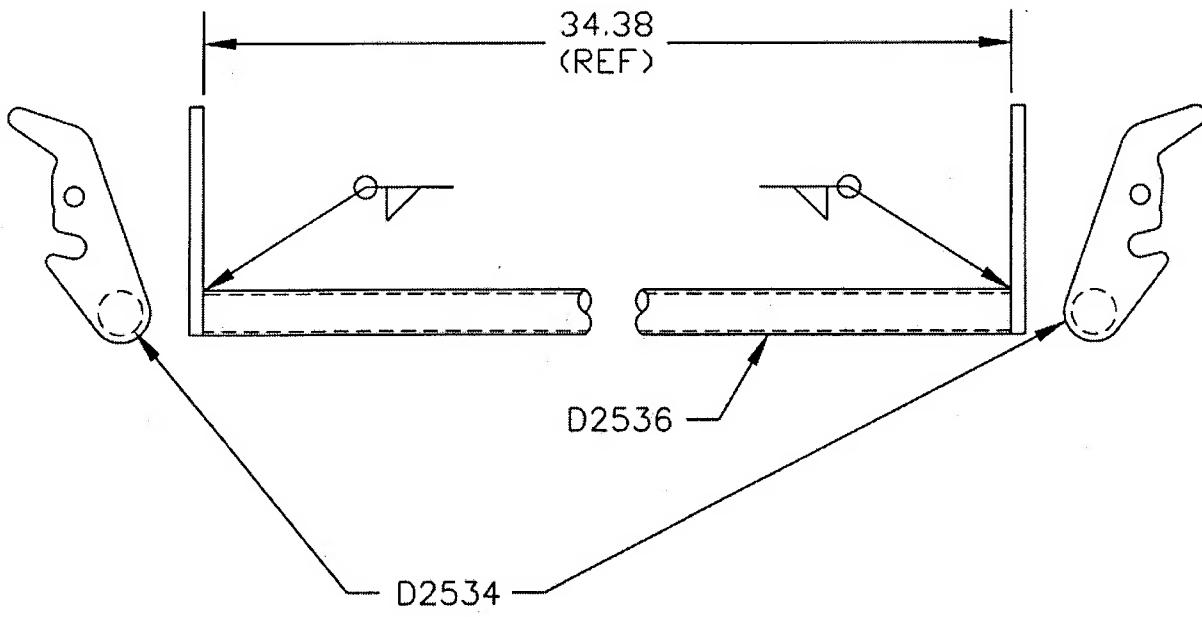
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530 REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[initials]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27556